

Re-Print



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3295-041

Job Sheet 199823



Part No: D3295-041

Job Qty: 10 pcs

Part Name: Replacement Interior Window For -111



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/3/19

Job Tracking No:

Due Date: 9/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP C 05.06.20 D3295-1 no longer made in-house KJ/JLM IPP Rev:D Added DT8822 07-03-20
JLM IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	9/23/19	9/23/19	0.04	1.55	Waterjet - Flow		2019/09/18
110	QC 2	10 pcs	9/23/19	9/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		

PRIORITY

PLST-61

Plex 9/18/19 1:17 PM dart.leroux.jason

130 Small Fab - 2 - B4B	10 pcs	9/23/19	0.00 2.17	QC 8 - 57	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 QC 5	10 pcs	9/23/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	10 pcs	9/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	

DAS
58
9-89

SEP 19 2019

Pto
1 Mchp
(9)DAS
4
SEP 19 2019
8-8DAS
28
9-89

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	10 pcs	9/23/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Small Fab) 140 - QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MLEXS.125-9034-01	1/8" 9034 Lexan Sheet (Clear)	12.4000 sf (1.24 ea)	100-Waterjet - Flow - 1	5192724	
D2728-1	Dart Logo Label Small	10 pcs (1 ea)	130-Small Fab - 2 - B4B		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	MLEXS.125-9034-01	12	83	0	
130-Small Fab - 2 - B4B	D2728-1	10	3,000	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order:	199823
Description: Window		Part Number:	D3295
Inspection Dwg: D3295 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	Ø.155	1		V.D. 02	
17.13	+/-0.030	17.13	1		Typ	
10.43	+/-0.030	10.43	1			
14.35	+/-0.030	14.35	1			
8.98	+/-0.030	8.98	1			
0.625	+/-0.010	.627	1			
7.109	+/-0.010	7.108	1			
15.845	+/-0.010	15.845	1			
2.308	+/-0.010	2.309	1			
5.420	+/-0.010	5.423	1			
9.402	+/-0.010	9.404	1			
1.312	+/-0.010	1.314	1			
6.260	+/-0.010	6.263	1			
12.520	+/-0.010	12.520	1			
0.313	+/-0.010	0.312	1			
3.750	+/-0.010	3.755	1			
8.150	+/-0.010	8.152	1			
9.006	+/-0.010	9.009	1			
0.125	+/-0.010	.123	1			

Measured by:	pc	Audited by:	DAS 40	Preliminary Approval:	
Date:	19/09/18	Date:	9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	

Entered:

Date:

LM Oct 25/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7570

Route update only ☐

Job: <u>199823</u> Part No.: <u>D3295-041</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐																						
Date: SEP 19 2019	Sequence #: <u>140</u>	QTY Affected: <u>10810</u>		MRB (QS1042) <u>68</u> 9-89		SEP 19 2019																						
Description Work Order Deviation				Disposition																								
<i>1 part in scrap log</i> <i>Scratch on it</i>				<i>Scrap - destroy</i> <i>No replace</i>																								
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Bending	Misaligned/off center	Folio/Program	Crushing	BOM/Route	Grain Direction	Cracks	Broken/Damage/Defect	Weld	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Marks/Chatter	Drill Holes	Out of Sequence	Mislabeled	Fit/Function	Off-set/Set-up
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		Other/Details:																										
Completed By DAS <u>58</u> SEP 19 2019		Lead hand / Supervisor DAS <u>30</u> SEP 19 2019																										
QC / QA Coordinator DAS <u>89</u> SVD SEP 19 2019																												